



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2940-1

Job Sheet 185735



Part No: D2940-1

Job Qty: 3 ea

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/2/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV C IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-1		LT 2018-11-04
100	CNC Vertical Machining	3 pcs	11/2/18	11/2/18	0.32	7.14	HAAS1-2		KF 2018-11-04
110	QC	3 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-1		KF 2018-11-04
120	QC	3 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-1		J.C.L. 18-11-04
130	Crosstubes	3 pcs	11/2/18	11/2/18	0.00	0.38	Crosstubes-2		AS 18-11-4
140	QC	3 pcs	11/2/18	11/2/18	0.00	0.00	QC5		38
170	Packaging	3 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1	LG 51	AS 18-11-5
180	QC21-SA	3 Ea	11/2/18	11/2/18	0.00	0.00	QC21		21

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 130 - Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG052

Scotchweld 138852 exp 4/19

S124357

Fm158926-0

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	1.5000 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK081	2	3	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S124358



Part: D2940-1

Job No: 185735

Serial No/Batch: S124358

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/04/18

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633		
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493		
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350		
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640		
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118		

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DART AEROSPACE LTD		Work Order: 185735
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	
AB	0.490	0.510		0.500	0.500	0.500	0.500	
AC	0.140	0.160		0.150	0.150	0.150	0.150	
AD	3.510	3.530		3.518	3.517	3.514	3.513	
AE	1.633	1.673		1.659	1.658	1.659	1.659	
AF	1.493	1.513		1.509	1.509	1.509	1.509	
AG	0.040	0.060		0.054	0.054	0.054	0.054	
AH	0.188	0.193		0.188	0.188	0.188	0.188	
AI	0.140	0.160		0.155	0.155	0.155	0.155	
AJ	2.518	2.538		2.525	2.525	2.525	2.525	
AK	0.040	0.060		0.050	0.050	0.050	0.050	
AL	0.010	0.020		0.010	0.010	0.010	0.010	
AM	0.140	0.160		0.160	0.160	0.160	0.160	
AN	0.350	0.450		0.430	0.430	0.430	0.430	
AO	0.240	0.260		0.250	0.250	0.250	0.250	
AP	0.150	0.170		0.150	0.154	0.152	0.153	
AQ	0.053	0.073		0.063	0.063	0.063	0.063	
AR	101.64	105.64		103.64	103.64	103.64	103.64	
AS	0.260	0.267		0.261	0.261	0.261	0.261	
AT	0.053	0.073		0.0625	0.0625	0.0625	0.0625	
AU	4.118	4.138		4.128	4.128	4.127	4.128	
AV								
AW								
Accept/Reject								

Measured by: <i>KH</i>	Date: 2018-11-03
Audited by: <i>J.C. - L. 18-01-04</i>	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

